

Date: Friday, 12/12/2008 2:24:20 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 44062	
Estimate Number : 13310	
P.O. Number :	Part Number : D37931
This Issue : 12/12/2008 S.O. No. :	Drawing Number : D3793 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 43459	Material :
Written By :	Due Date : 19/12/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.12.15</u>	
Comment : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.6197 sf(s)/Unit Total : 7.4365 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 110076 B 8-12-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3793
 Dwg Rev: A
 Prog Rev: A

1B 8-12-15

(13)

2-Deburr if necessary 1B 8-12-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-12-15



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J 02/12/16 (13)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

J 02/12/16 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/12/2008 2:24:20 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44062

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 08/12/31 (13)
08/01/05 (X13)

7.0

POWDER COATING

POWDER COATING



m/09648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL 08/01/06

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-01

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

HL

09-06-01

(X13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

MF 09-01-06

Job Completion:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44002
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1	

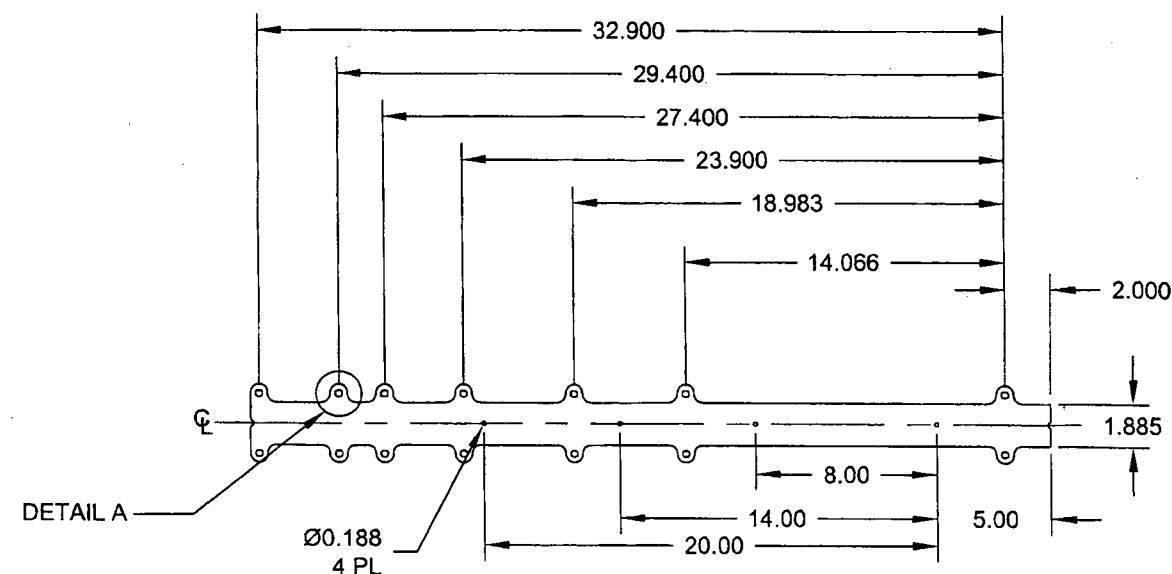
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

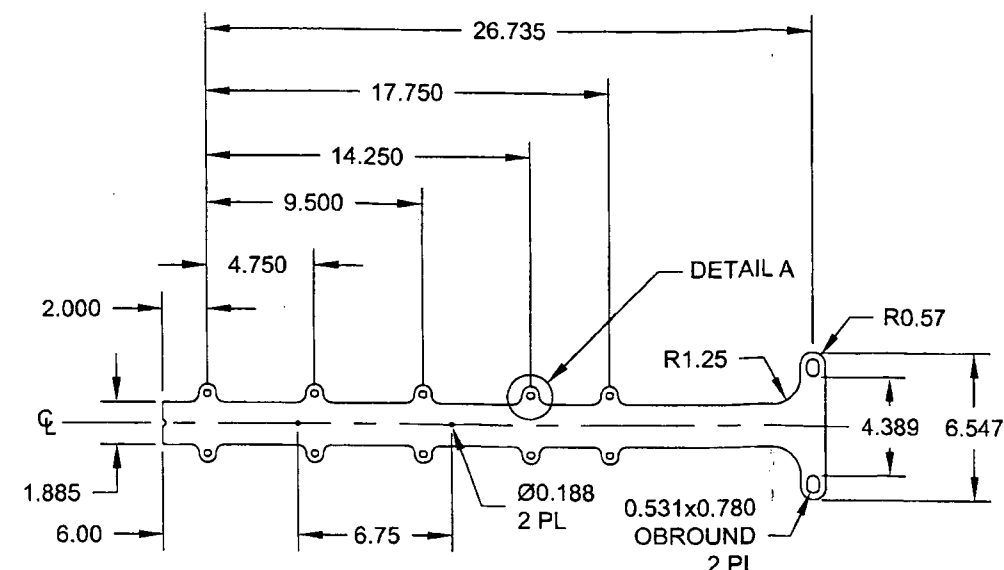
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.188	*			
0.300 x 0.300	+/-0.010	0.300 x 0.300	*			
1.885	+/-0.010	1.888	*			
2.000	+/-0.010	2.000	*			
5.00	+/-0.030	5.001	*			
8.00	+/-0.030	8.000	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.066	+/-0.010	14.066	*			
18.983	+/-0.010	18.983	*			
23.900	+/-0.010	23.900	*			
27.400	+/-0.010	27.400	*			
29.400	+/-0.010	29.400	*			
32.900	+/-0.010	32.900	*			
0.040	+/-0.010	0.039	*			

Measured by: JB	Audited by: J	Prototype Approval:	N/A
Date: 8-12-15	Date: 08/02/16	Date:	N/A

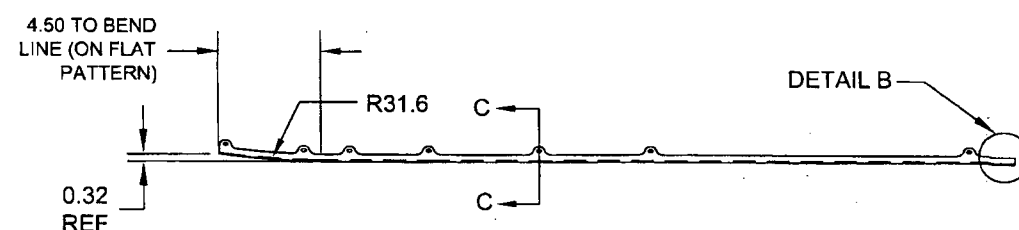
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

RELEASED
08.05.23/11

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WORK ORDER
NO. 114002

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION		BY DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	DS	D3793	SHEET 1 OF 2
APPROVED	HL	TITLE	SCALE
DE APPR.	HL	WEARSHOE	NTS
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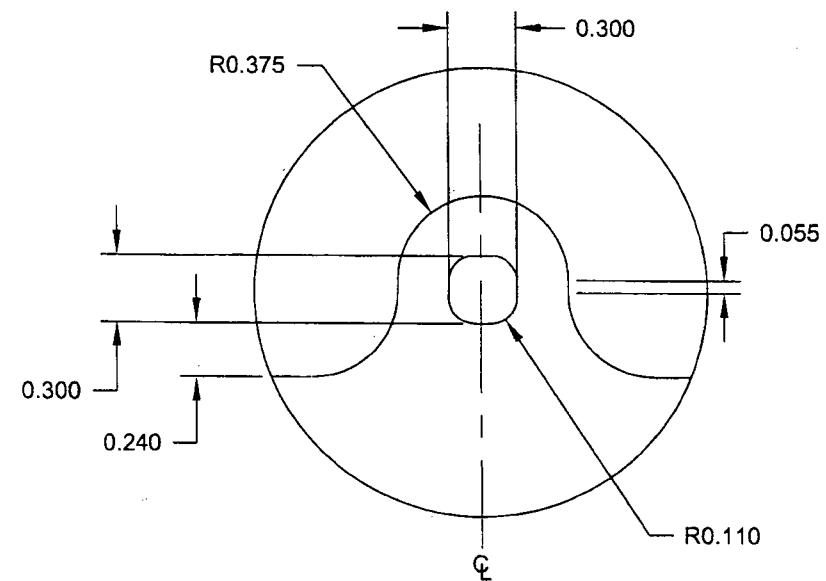
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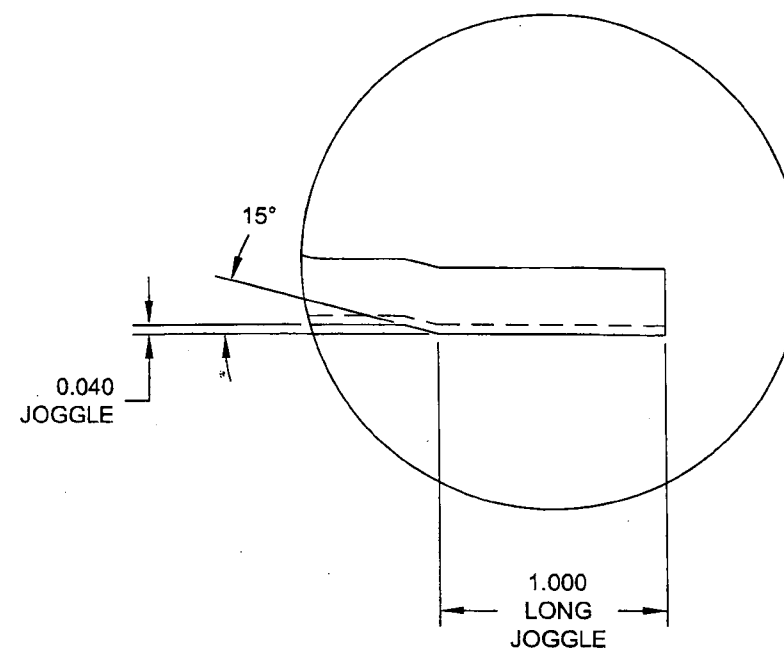
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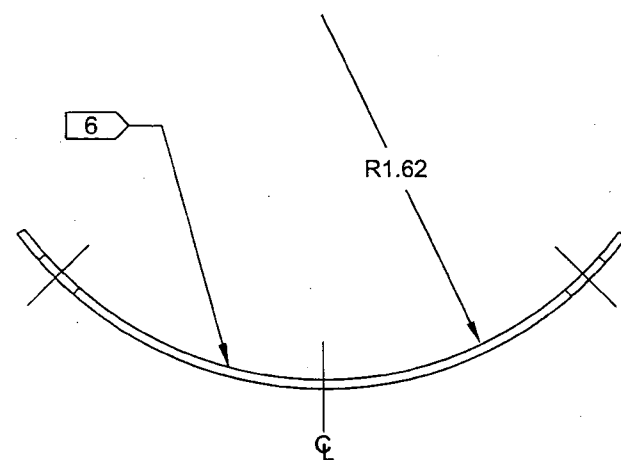
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DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

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08-05-13

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